

Work Order ID 69198



Page 1

Wednesday, May 04, 2011 12:29:02 PM

Item ID: D4368-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Fwd Wearplate Assembly

Start Date: 5/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

AK

Date: 11.05.04

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4368

PA2

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4368-1)

Dwg Rev: *PA2*

Prog Rev: *PA2*

2-Deburr if necessary

B11-5-4

1

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-4








PRELIMINARY ISSUE




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Item ID:	D4368-041	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Fwd Wearplate Assembly					
Start Date:	5/4/2011	Start Qty:	1.00	Cust Item ID:		
Required Date:	5/6/2011	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 - inspector to PA2 Dry only 8/10/05		- inspector to PA2 PM only 8/10/10					
130  Brake NC Brake NC	Form as per dwg Memo *** Jigs DT8261 and DT8326.***	0.00 0.00		SB 11/05/05 SB 11/05/10		①			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 - inspector to PA2 Dry only 8/10/02				④			

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Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 		0.00							
Large Fab									
Large Fab	Memo 1- on D4369-1, fill cut outs with hardcoat welding rod as per dwg D4368 **DT9756** 2059 B Hardcoat Welding Rod BATCH#: <u>M117657</u> 2-weld D4369-1 to wearplate by positioning holes together as per dwg D4368 304 S.S. Welding Rod BATCH #: <u>107051</u> 3-Transfer drill holes in bar	0.00							<u>E2 11-5-31</u>
160 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
Quality Control	Memo	0.00							<u>11.06.02</u>

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Start Date: 5/4/2011 Start Qty: 1.00

Required Date: 5/6/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

QC5- Inspect part completeness to step on W/O

0.00 - inspect to PAR



QC

Memo

0.00

Quality Control

Day only
Sulob62 (x1)

180

0.00



Small Fab

Memo

0.00

Small Fab

1- After finish, coat entire top (concave) surface as per note 10 on sheet 2 dwg D4368.

W116210

MA 11 06 06 (1)

190

QC5- Inspect part completeness to step on W/O

0.00 - inspect to PAR



QC

Memo

0.00

Quality Control

Day only
Sulob62

Work Order ID 69198

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Page 5

Item ID: D4368-041

Accept

Revision ID: PRELIM

Item Name: Fwd Wearplate Assembly

Start Date: 5/4/2011 Start Qty: 1.00

Required Date: 5/6/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
210 QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
Quality Control									

MF
11-06-23

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE 11/05/04

Picklist Print

Page 1

Wednesday, May 04, 2011 12:28:59 PM

Work Order ID: 69198



Parent Item: D4368-041



Parent Item Name: Fwd Wearplate Assembly

Start Date: 5/4/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4369-1		Manufactured	No			150	Each	1.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Bar

Location	Loc Qty	Loc Code
----------	---------	----------

WA	1	
----	---	--

68405	1	
-------	---	--

M304S18GA		Purchased	No			100	sf	129.0000	3.171	3.337895			
-----------	--	-----------	----	--	--	-----	----	----------	-------	----------	--	--	--



304/316 .050 Sheet

FB11-5-4

Location	Loc Qty	Loc Code
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MAT020	129	
--------	-----	--

112178	4	
--------	---	--

113062	18	
--------	----	--

116135	26	
--------	----	--

116604	12	
--------	----	--

116979	69	
--------	----	--

~~116979~~

116604
~~116979~~

①

DART AEROSPACE LTD		Work Order: 69198
Description: FWD WEAPONITE		Part Number: D4368-041
Inspection Dwg: D4368-1, Rev: p12		Page 1 of 1

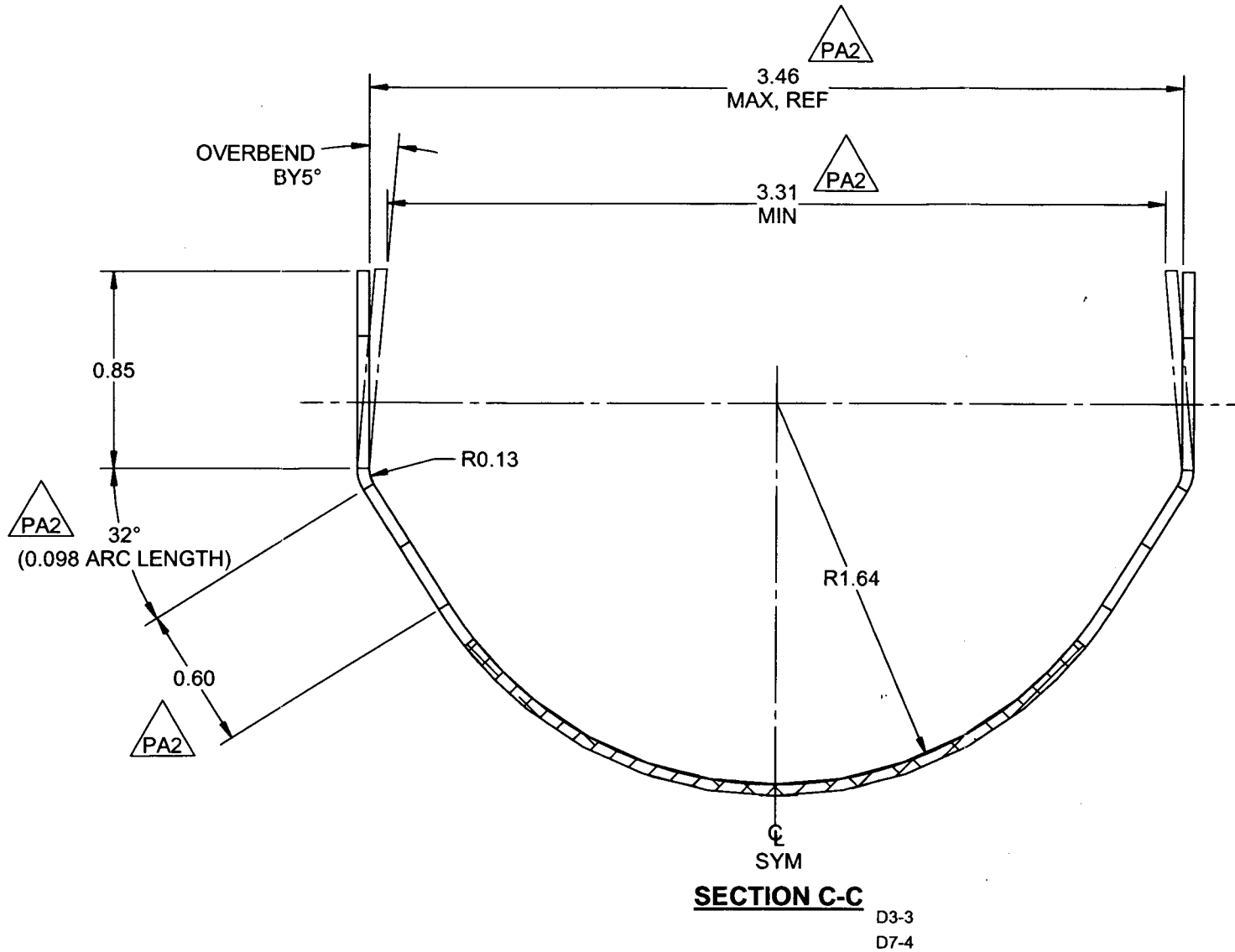
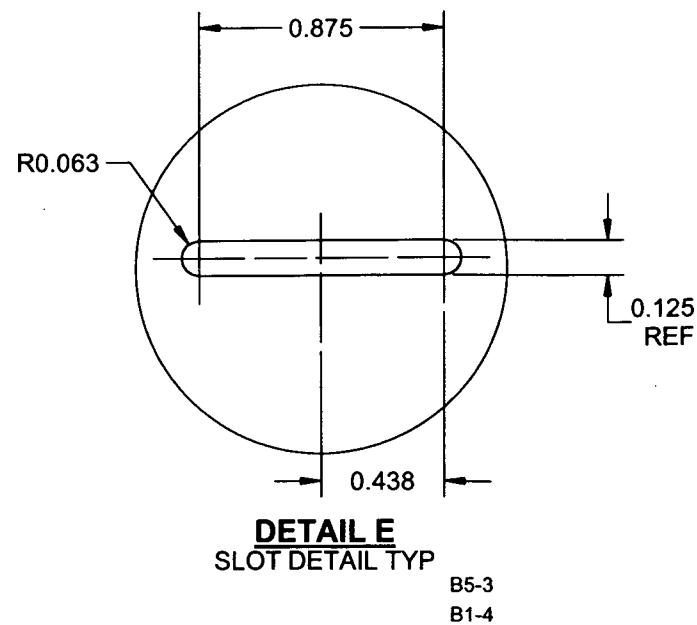
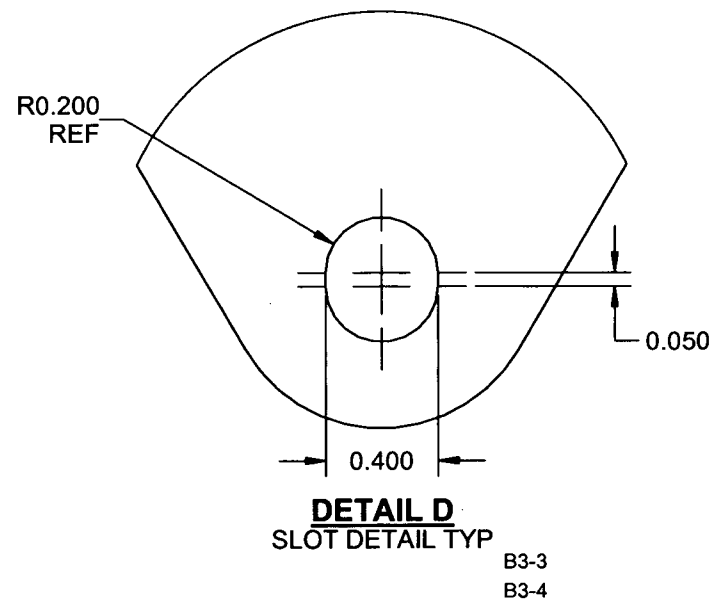
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+ .005 - .001	.190	✓		✓ FB02	
.400	± .010	.401	✓		✓	
.050	± .010	.050	✓		✓	
.125	± .010	.130	✓		✓	
.875	± .010	.875	✓		✓	
3.00	± .030	3.009	✓		✓	
5.377	± .010	5.372	✓		✓	
4.00	± .030	4.003	✓		✓	
1.20	± .030	1.20	✓		✓	
5.20	± .030	5.20	✓		✓	
8.00	± .030	8.00	✓		✓	
38.091	± .010	38.091	✓		T	
52.250	± .010	52.250	✓		T	
2.25	± .030	2.240	✓		✓	
15.000	± .010	15.00	✓		T	
30.000	± .010	30.000	✓		T	
49.245	± .010	49.245	✓		T	
61.245	± .010	61.245	✓		T	
71.745	± .010	71.745	✓		T	
74.61	± .030	74.61	✓		T	
.050	± .010	.049	✓		✓	

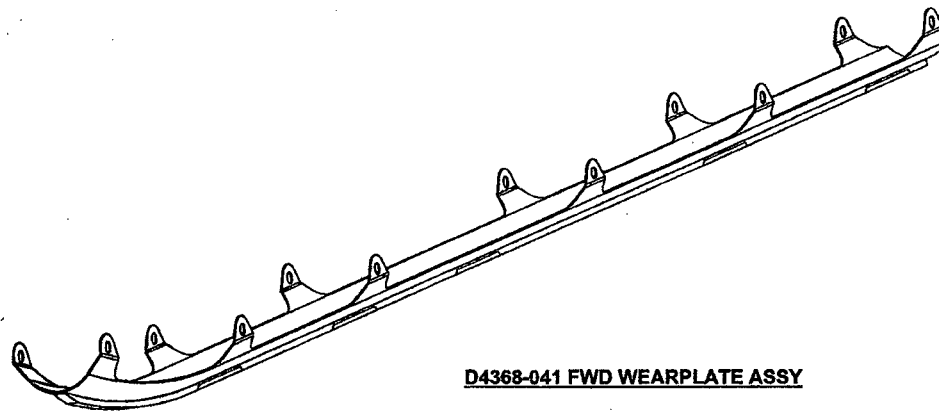
Measured by: RB	Audited by: S	Prototype Approval:
Date: 11-5-10	Date: 11/6/10	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

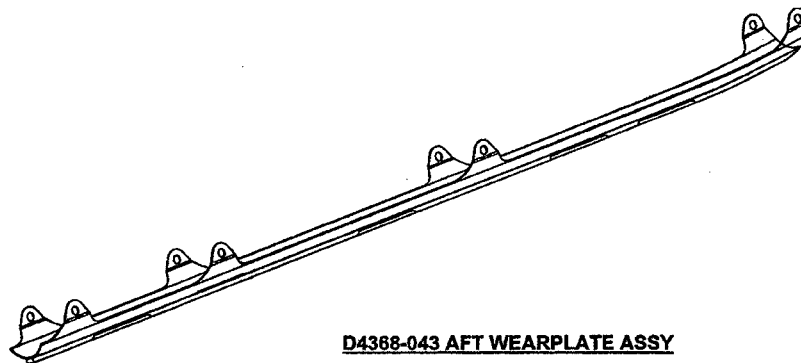


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ISSUE**

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4368	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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D4368-041 FWD WEARPLATE ASSY

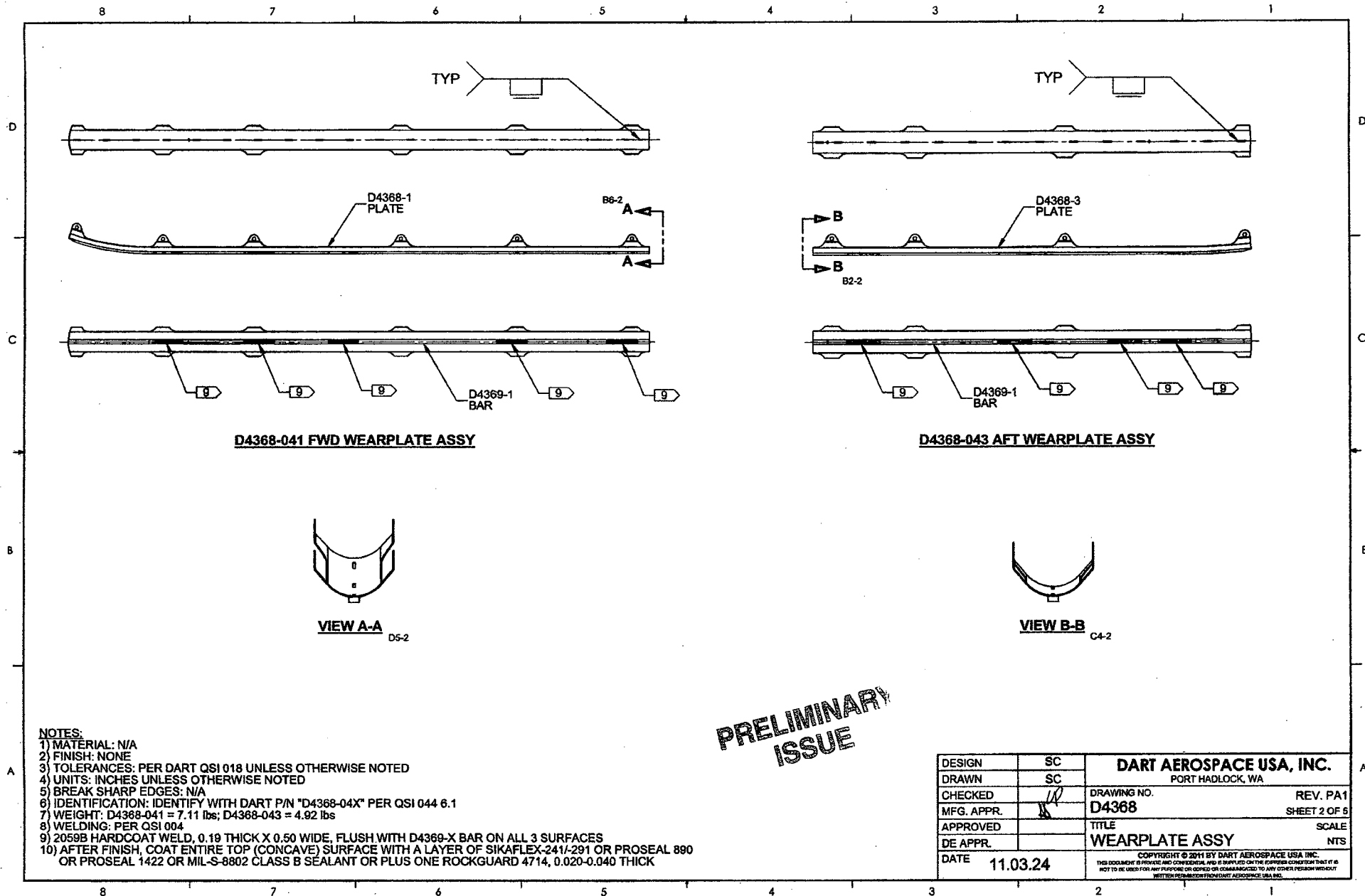


D4368-043 AFT WEARPLATE ASSY

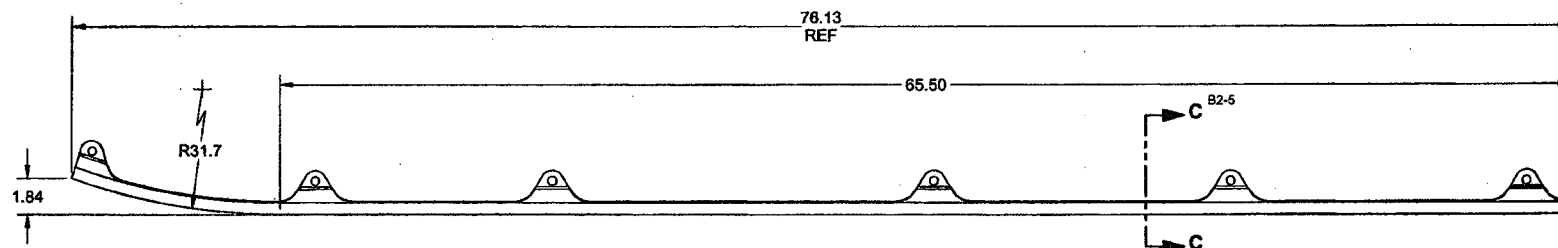
ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X		D4368-041	FWD WEARPLATE ASSY
		X	D4368-043	AFT WEARPLATE ASSY
1	1		D4368-1	PLATE
2		1	D4368-3	PLATE
3	1		D4369-1	BAR
4		1	D4369-3	BAR
5	A/R	A/R	2059B	HARDCOAT
6	A/R	A/R	ROCKGUARD 4714	SEALANT

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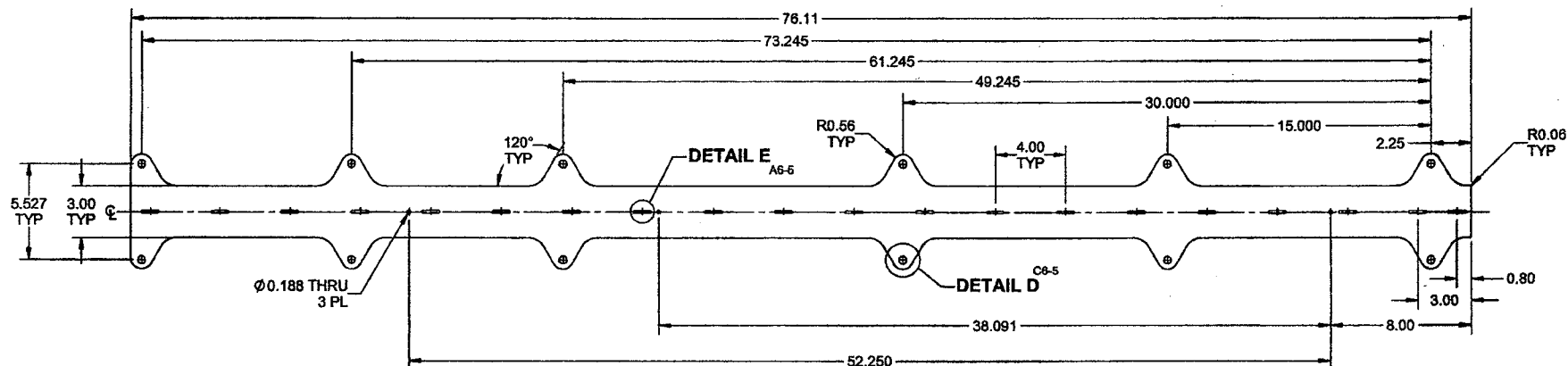
PA1	NEW ISSUE	SC	11.03.24
REV.	DESCRIPTION	BY	DATE
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8 7 6 5 4 3 2 1



D4368-1 PLATE
(MAKE FROM D4368-1F)



D4368-1F PLATE

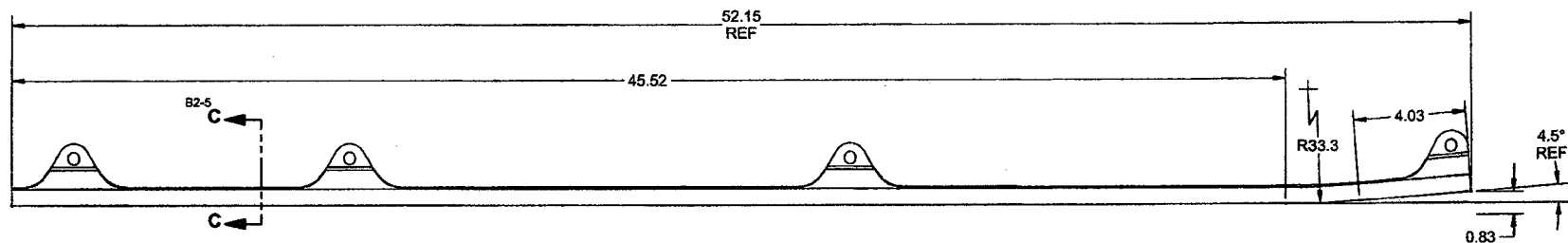
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.72 lbs

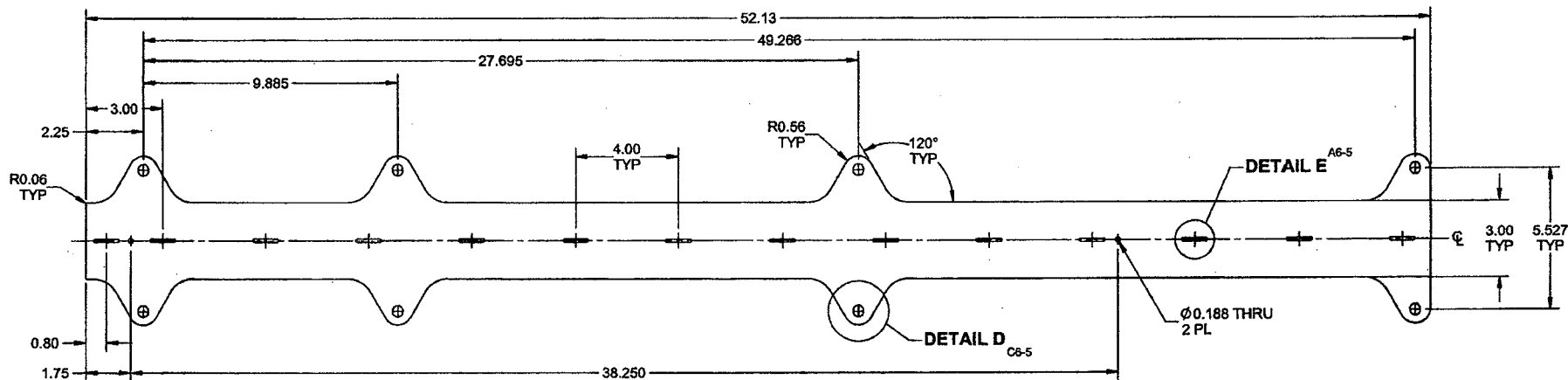
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8 7 6 5 4 3 2 1



D4368-3 PLATE
(MAKE FROM D4368-3F)



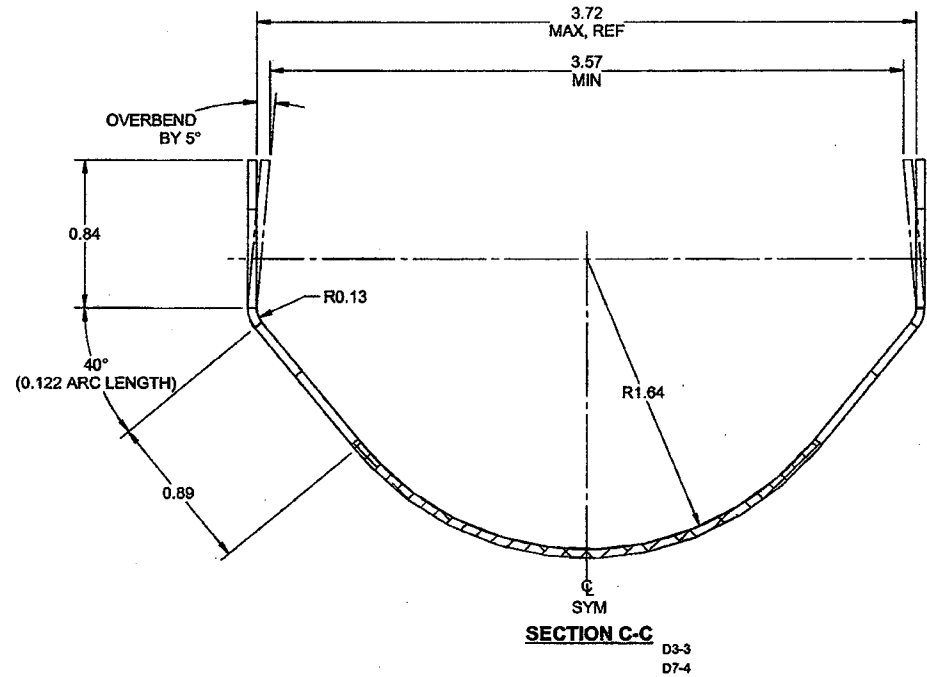
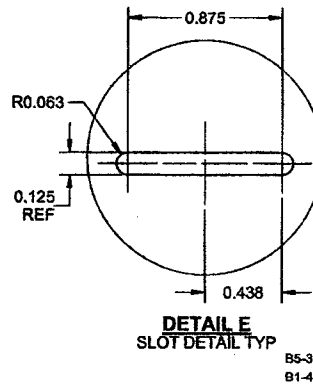
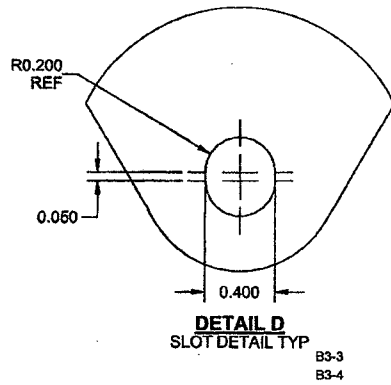
D4368-3F PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.53 lbs

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